Work Order ID 105215

105215

July-29-13 1:45:15 PM

Item ID: D206-667-247TRN **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube Assembly, Mid Aft

Start Date: 7/29/13 **Start Qty:** 1.00 *1*

Required Date: 8/12/13 **Req'd Qty:** 1.00 *1*

Reference: **Cust Item ID:**

Customer:

Approvals: **Process Plan:** MCS **Date:** 13-07-29 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D206-667-247	A								
100		0.00							
100	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DTxxxx on both ends as per Folio FB030 2-Turn first side as per Folio FB030 3-File down transition lines smooth. FOLIO REV: AA DWG REV: A					1	0		amn/kc 13-7-30
110	QC1- Inspect dimensions to dimension sheet	0.00							
110									
QC	**Memo**	0.00							
Quality Control						1	0		amn.L 13/08/01

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 105215

July-29-13 1:45:15 PM

105215

Item ID: D206-667-247TRN

Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Start Date: 7/29/13 **Start Qty:** 1.00 *1*

Required Date: 8/12/13 **Req'd Qty:** 1.00 *1*

Reference:

Approvals: **Process Plan:** _ **Date:** _ **Tooling:** **Date:**

QC: _ **Date:** _ **SPC (Y/N):** **Date:**

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	**Memo**	0.00				1	0		
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FB030 2-File down transition lines smooth. 3-Remove sand and plugs FOLIO REV: A1 DWG REV: A								13/08/01
130	QC1- Inspect dimensions to dimension sheet	0.00							
130									
QC	**Memo**	0.00				1	0		
Quality Control									13/08/01
140	QC8- Inspect parts - second check	0.00							
140									
QC	**Memo**	0.00							
Quality Control									13-08-02

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
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- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 105215

July-29-13 1:45:15 PM

105215

Item ID: D206-667-247TRN

Revision ID:

Item Name: Crosstube Assembly. Mid Aft

Start Date: 7/29/13 **Start Qty:** 1.00 *1*

Required Date: 8/12/13 **Req'd Qty:** 1.00 *1*

Reference:

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145		0.00							
145									
Crosstubes									
Crosstubes	**Memo**	0.00							
	GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.								
150		0.00							
150									
HandFXtube	**Memo**	0.00							
Hand Finishing Crosstubes	1- PRESSURE WASH X-TUBE INSIDE AND OUT								
	2- ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

QB 13-08-06

13/08/13

DAS 05 13/08/13

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 105215

July-29-13 1:45:15 PM

105215

Item ID: D206-667-247TRN

Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Start Date: 7/29/13 **Start Qty:** 1.00 *1*

Required Date: 8/12/13 **Req'd Qty:** 1.00 *1*

Reference:

Approvals: **Process Plan:** _____ **Date:**

QC: _____ **Date:**

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Tooling:

SPC (Y/N):

Run Start *NR1*

Date:

Stop *NR2*

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Packaging								
Packaging	**Memo**	0.00							
Packaging	Identify and stock in kanban rack Location: LG								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

13-08-13

MCJ 13-08-14

13.8.14

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Cut Too Short
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- ☐ Positioned Wrong
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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

July-29-13 1:45:18 PM

Work Order ID: 105215 *105215*

Parent Item: D206-667-247TRN *D206-667-247TRN*

Parent Item Name: Crosstube Assembly, Mid Aft

Start Date: 7/29/13 **Required Date:** 8/12/13

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP rev:A 11.01.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6004-115		Manufactured	No			100	Each	31.0000	1	1			
D6004-115									**				
Crosstube Material													

Location	Loc Qty	Loc Code	
LG015	31		
34685	1		
75636	30		1

KC 13-7-30

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
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- ☐ Inspection Strip in Tube
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- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

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- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

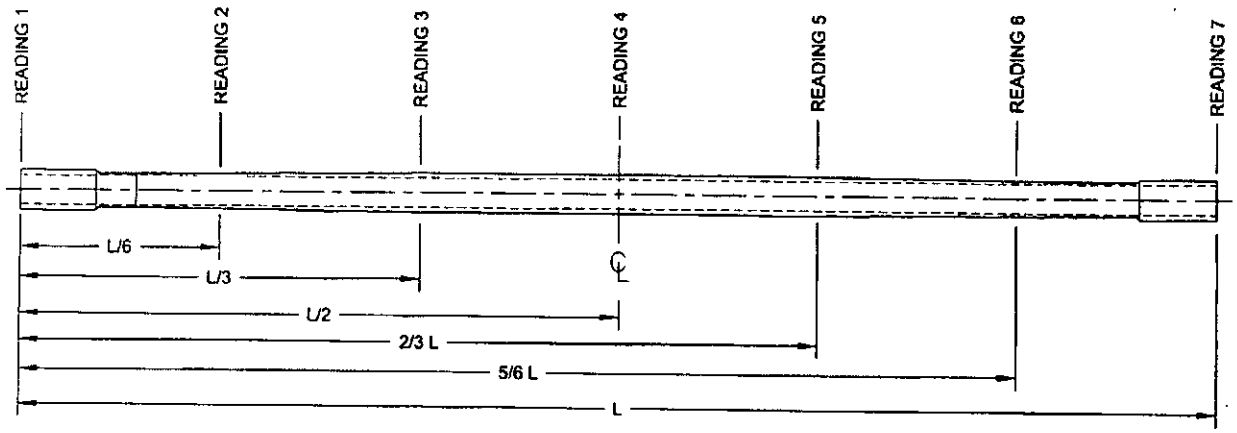
DART AEROSPACE LTD	Work Order:	105215
Description: Crosstube Assembly, Mid Aft	Part Number:	D206-667-247TRN
Inspection Dwg: D206-667-247 **Rev:** A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.492	✓		vern	CWC-08
	2.025	+0.005/-0.000	2.029	✓		↓	
	2.079	+0.005/-0.000	2.083	✓			
	2.145	+0.005/-0.000	2.149	✓			
	2.209	+0.005/-0.000	2.212	✓			
	2.287	+0.005/-0.000	2.290	✓			
	2.363	+0.005/-0.000	2.364	✓			
	0.200	+/-0.010	.200	✓		vern	CWC-08
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.00	✓		"	
	R0.063	+/-0.010	.063	✓		"	
	4.438	+/-0.010	4.440	✓		vern	CWC-08
SIDE B	2.490	+0.005/-0.000	2.491	✓		vern	CWC-08
	2.025	+0.005/-0.000	2.030	✓		↓	
	2.079	+0.005/-0.000	2.082	✓			
	2.145	+0.005/-0.000	2.148	✓			
	2.209	+0.005/-0.000	2.212	✓			
	2.287	+0.005/-0.000	2.289	✓			
	2.363	+0.005/-0.000	2.363	✓			
	0.200	+/-0.010	.200	✓		vern	CWC-08
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.00	✓		"	
	R0.063	+/-0.010	.063	✓		"	
	4.438	+/-0.010	4.440	✓		vern	CWC-08
	99.76	+/-0.020	99.76	✓		TAPE	LG-16

DART AEROSPACE LTD	Work Order:	105215
Description: Crosstube Assembly, Mid Aft	Part Number:	D206-667-247TRN
Inspection Dwg: D206-667-247 Rev: A		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.348	.353	.364	.359	.016	
READING 2 L= 11	.155	.158	.168	.163	.013	
READING 3 L= 23	.236	.240	.251	.246	.015	
READING 4 L= 49	.348	.355	.366	.358	.018	0.045"
READING 5 L= 23	.237	.243	.248	.238	.011	
READING 6 L= 11	.153	.157	.167	.166	.014	
READING 7 L= Cuff	.353	.349	.363	.359	.014	

Calibration Result

Actual Block Thickness: .100 .250

Sitescan 250 Measured Thickness: .100 .250

Measured by:		Audited by:		Preliminary Approval:	
Date:	13/08/02	Date:	13-08-02	Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	
B	12.02.02	Dimension 4.438 was 4.500	KJ	
C	12.06.01	Wall thickness form added	KJ	

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6004-115
 FINISHED LENGTH = 99.76±0.020
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

105215 MCJ
13-07-29

DEO ATTACHED

ECN # R-615
11.07.28

UNDER REVIEW
09.11.05.13

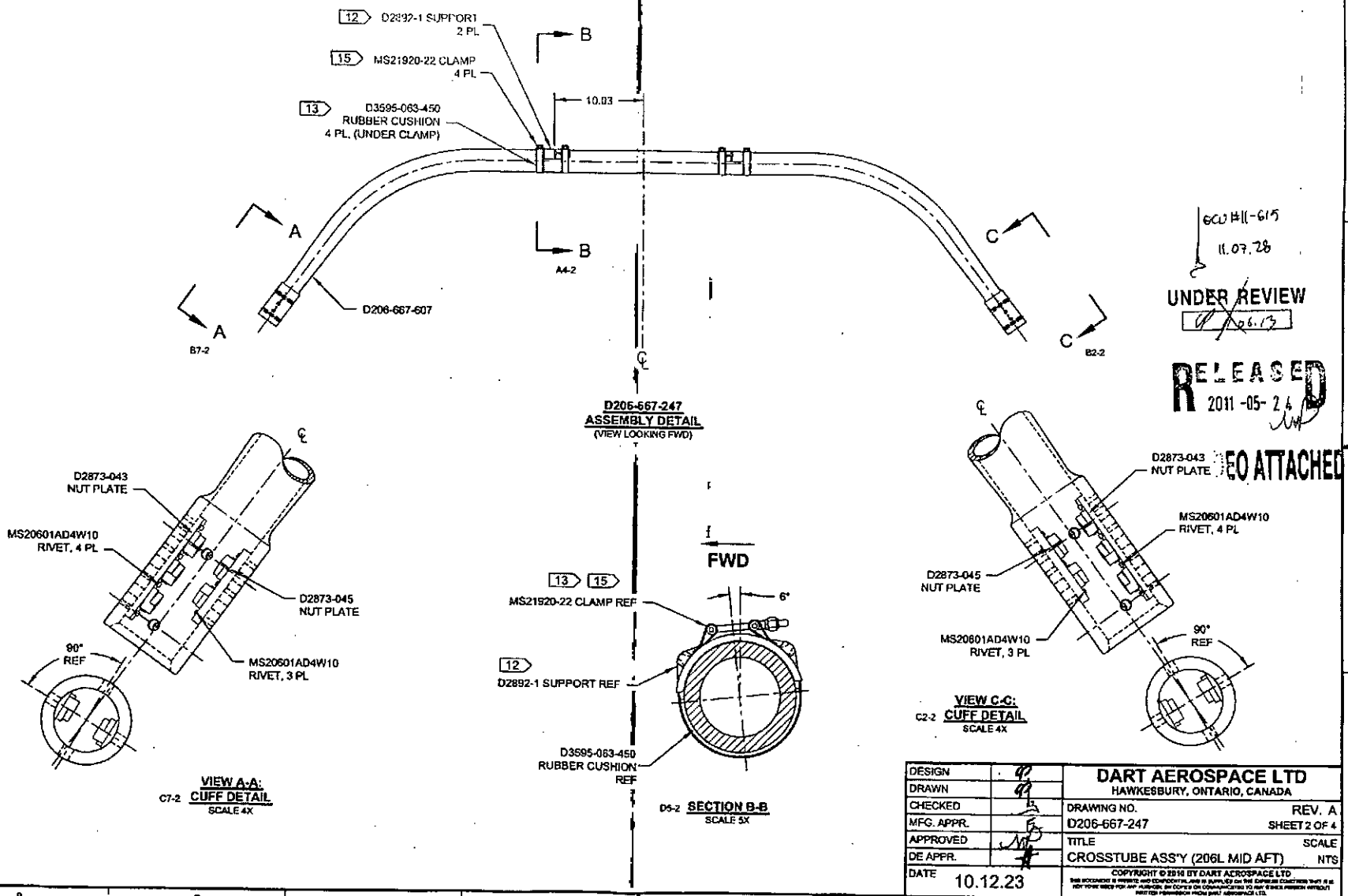
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2011-05-26

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	10.12.23

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	CP	
CHECKED		DRAWING NO. D206-667-247 REV. A
MFG. APPR.		SHEET 1 OF 4
APPROVED		TITLE CROSSTUBE ASS'Y (206L MID AFT) SCALE NTS
DE APPR.		
DATE	10.12.23	

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105215



ECO #11-615
11.07.28

UNDER REVIEW
06.13

RELEASED
2011-05-24

ECO ATTACHED

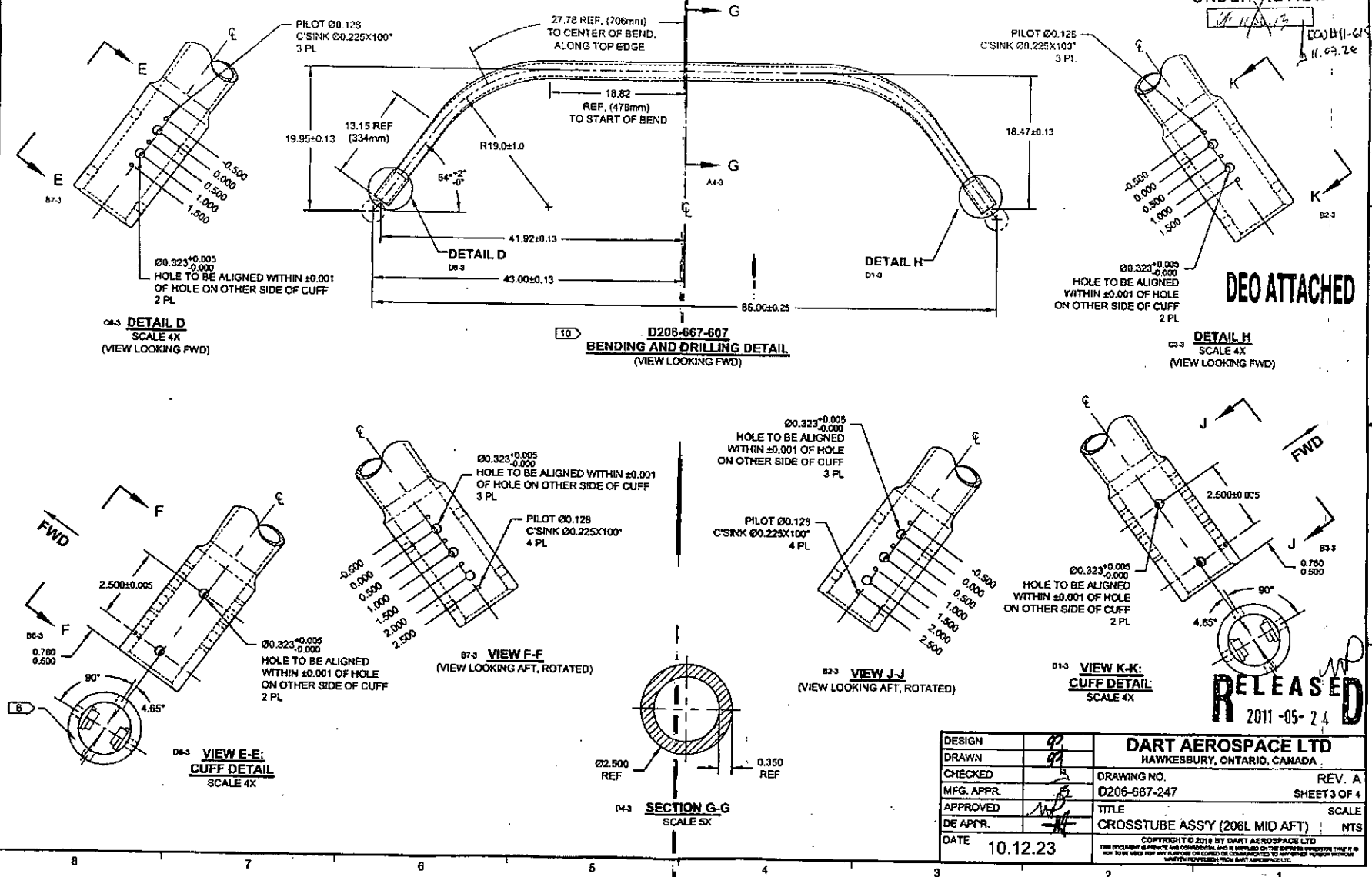
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DRAWN		
CHECKED		DRAWING NO. D206-667-247 REV. A
MFG. APPR.		SHEET 2 OF 4
APPROVED		TITLE CROSSTUBE ASS'Y (206L MID AFT) SCALE NTS
DE APPR.		
DATE 10.12.23		

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105215

UNDER REVIEW

ECN B11-615
11.09.26



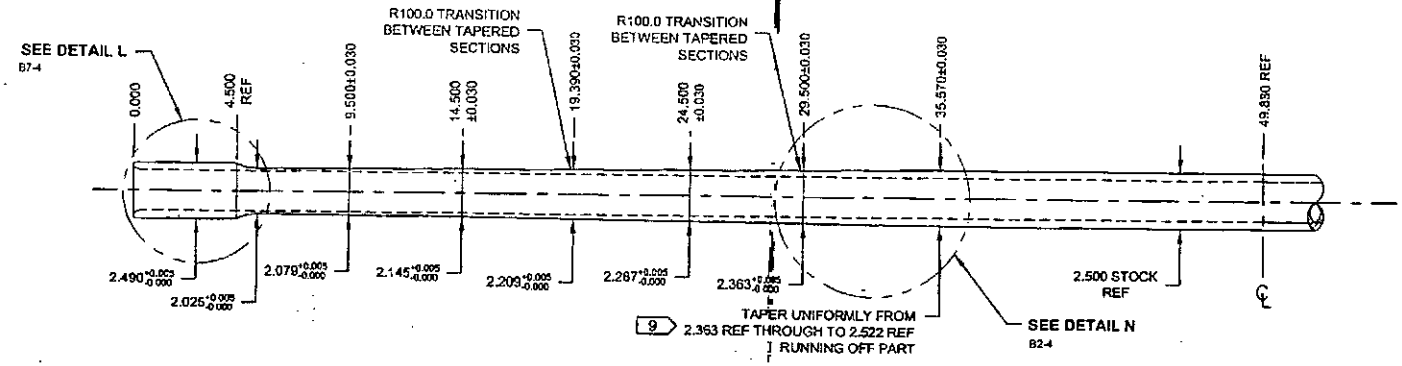
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2011-05-24

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. REV. A
CHECKED		D206-667-247 SHEET 3 OF 4
MFG. APPR.		TITLE SCALE
APPROVED		CROSSTUBE ASS'Y (206L MID AFT) NTS
DE APPR.		
DATE	10.12.23	

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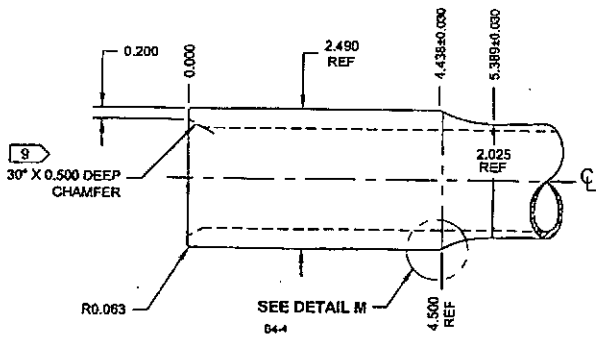


TURNING DETAIL

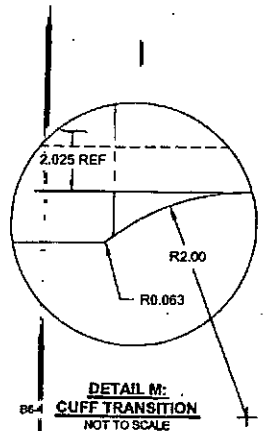
BCN #0-615
11.07.28

UNDER REVIEW
11.06.13

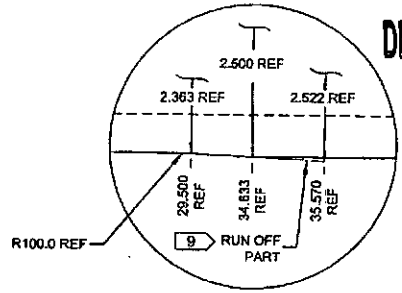
DEO ATTACHED



C7-4 **DETAIL L: CROSSTUBE CUFF**
SCALE 2.5X



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

RELEASED
2011-05-24

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D206-667-247 REV. A
MFG. APPR.		SHEET 4 OF 4
APPROVED		TITLE CROSSTUBE ASS'Y (206L MID AFT)
DE APPR.		SCALE NTS
DATE 10.12.23		

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105215

DRAWING NO.	TITLE REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D206-667-247	CROSSTUBE ASS'Y (206L MID AFT)		D206-667-247-A-1	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
99	AJS	KB	JMD	
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11-7-21

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -247	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2892-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28

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